

Date: Wednesday, 4/26/2006 12:32:22 PM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	SHUT-OFF VALVE BRACKET
<b>Job Number</b> :	26855		
<b>Estimate Number</b> :	12256		
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D3481041
<b>This Issue</b> :	4/26/2006	<b>S.O. No.</b> :	N/A
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3481 REV A
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A
<b>Previous Run</b> :	26184	<b>Drawing Revision</b> :	A
	<b>Type</b> :	<b>Material</b> :	N/A
	SMALL /MED FAB	<b>Due Date</b> :	4/28/2006
<b>Written By</b> :	<i>SEE COMMENT BELOW</i>		<b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> :	<i>SEE ABOVE USER &amp; DATE</i>		
<b>Comment</b> :	Est Rev: A New Issue 06-02-03 JLM		

## Additional Product

Job Number:



<b>Seq. #:</b>	<b>Machine Or Operation:</b>	<b>Description :</b>
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1.0	D3481043	bracket & clamp ass'y
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
1	D3481-3043	Bracket Assembly	

PTO

*inspect level 5/9* *SB* *106/04/27* (2)

2.0	BACN10YD3	CLIP FLOATING NUT
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	BACN10YD3	Clip	M19596

BACN10YD3

3.0	AN33A	Bolt
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN3-3A	Bolt	M18310

BACN10YD3

4.0	AN96010	Washer
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**Comment:** Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
4	AN960-10	Washer	M5579

BACN10YD3

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
06/04/27		Fabricate D3481-043 by hand as per drawing Fabricate D3481-3 by hand 304/316 SS M19704 Q52001445 M100202	B	06/04/27	1	B 06/04/27	B 06/04/27

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☐ No ☒ DQA: ☒ Date: 06/04/28  
 QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/26/2006 12:32:22 PM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SHUT-OFF VALVE BRACKET

Job Number: 26855

Part Number: D3481041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34811

ANGLE BRACKET



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D3481-1 Bracket 1326105

18 count 2

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Assemble as per Dwg D3481

18 count 2

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SB 06/04/27 1

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify with a fine point permanent marker and Stock

Location: 443

Pu 4/4/28 1

9.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/04/28

Job Completion



06-04-28

**Dart Aerospace Ltd**

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

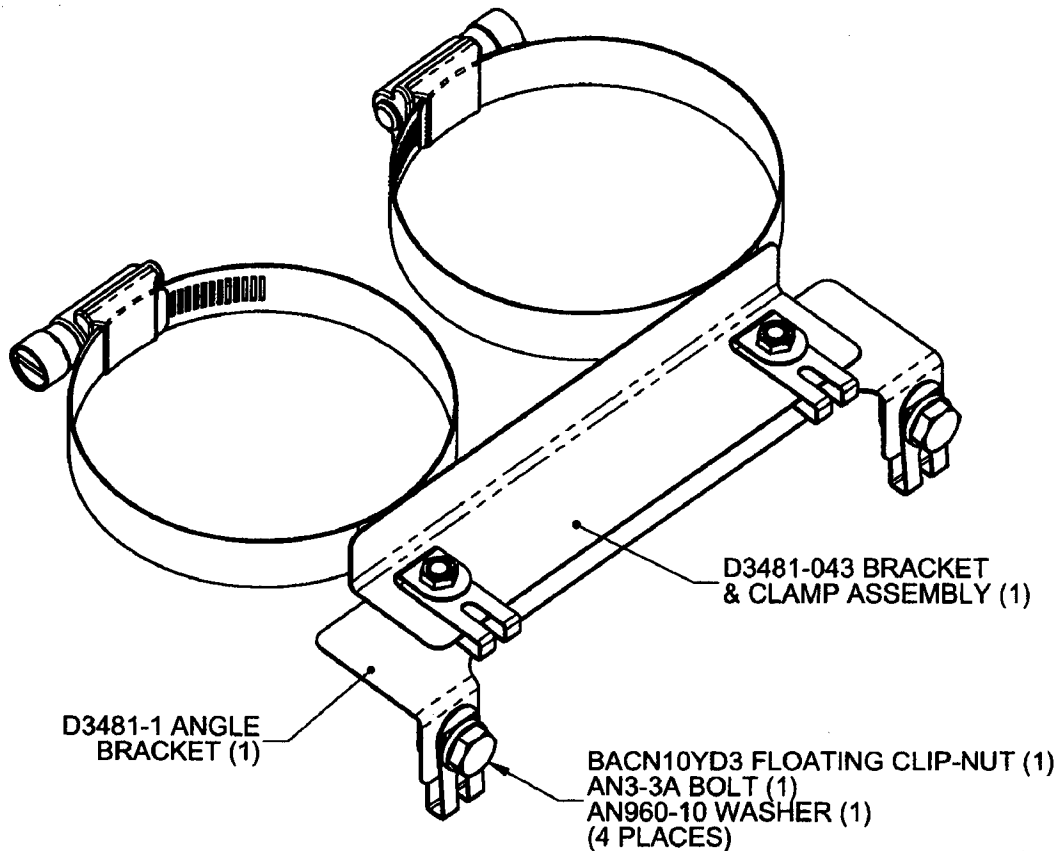
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3481</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>SHUT-OFF VALVE BRACKET</b>	SCALE 2:3
A	06.01.23	NEW ISSUE	

*[Signature]* 06.04.03



### **D3481-041 SHUT-OFF VALVE BRACKET**

- 1) IDENTIFY WITH DART P/N D3481-041 USING FINE POINT PERMANENT INK MARKER

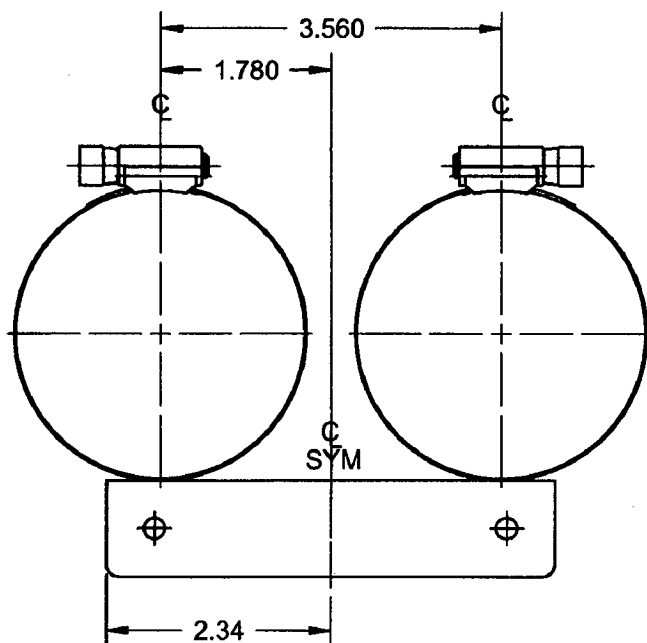
QTY -041	P/N	DESCRIPTION
X	D3481-041	SHUT-OFF VALVE BRACKET
1	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-1	ANGLE BRACKET
4	AN3-3A	BOLT
4	AN960-10	WASHER
4	BACN10YD3	FLOATING CLIP-NUT

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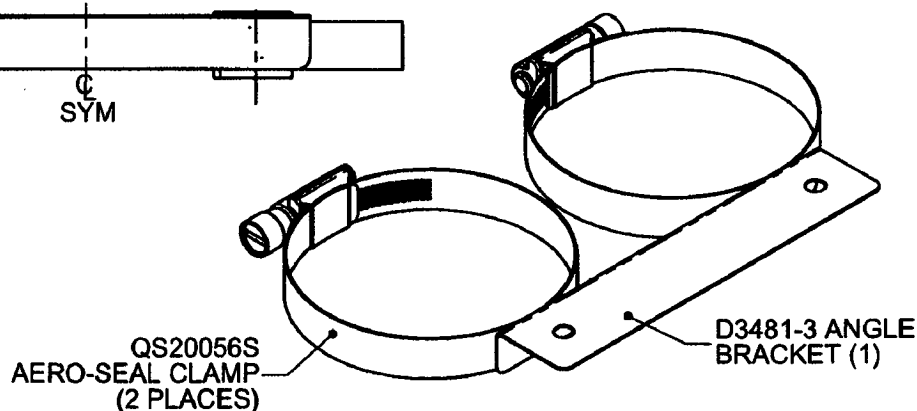
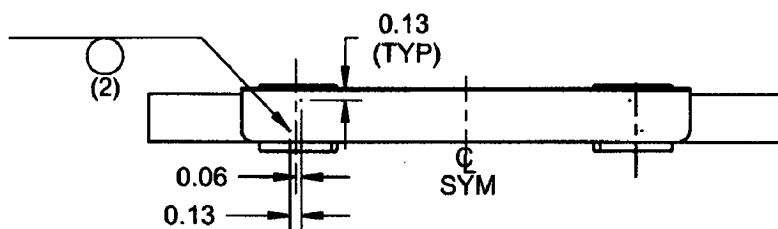
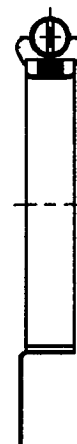
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DATE 06.01.23		TITLE SHUT-OFF VALVE BRACKET	SCALE 1:2



*[Signature]* 06.04.03



### D3481-043 BRACKET & CLAMP ASSEMBLY

#### NOTES:

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) ASSEMBLY IS SYMMETRICAL ABOUT CENTERLINE
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010

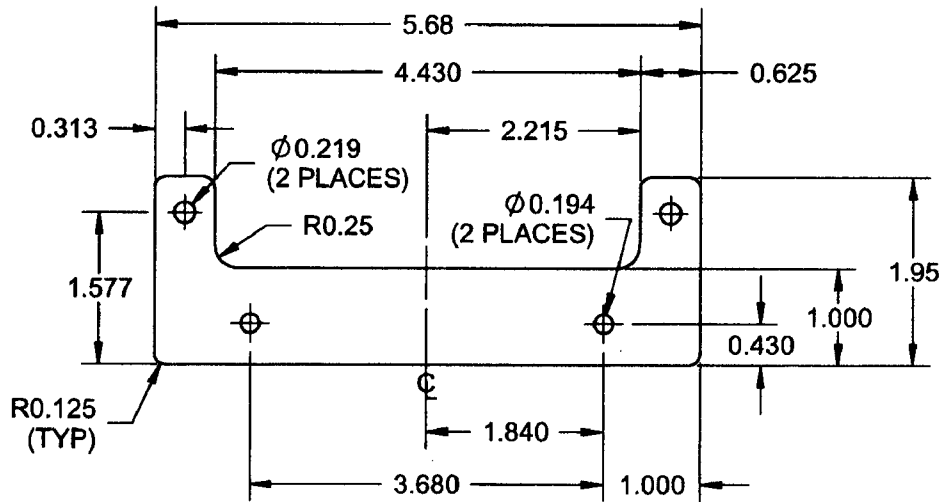
QTY -041	P/N	DESCRIPTION
X	D3481-043	BRACKET & CLAMP ASSEMBLY
1	D3481-3	ANGLE BRACKET
2	QS20056S	AERO-SEAL CLAMP

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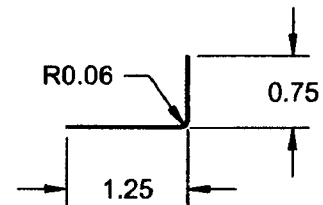
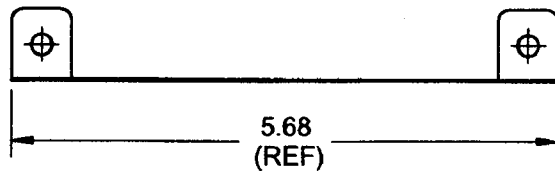
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DATE <b>06.01.23</b>		TITLE <b>SHUT-OFF VALVE BRACKET</b>	SCALE 1:2

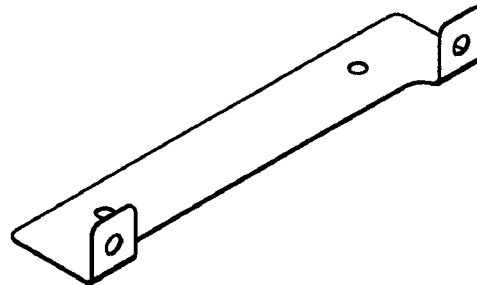


**D3481-1F FLAT PATTERN**



**D3481-1 ANGLE BRACKET**

*[Signature]* 06.04.03



**NOTES:**

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

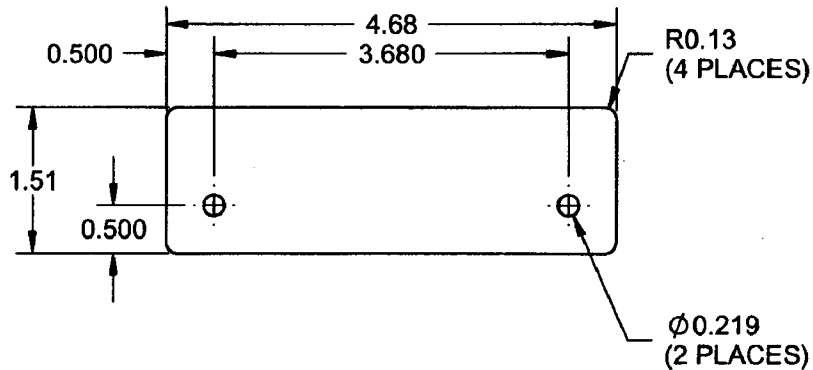
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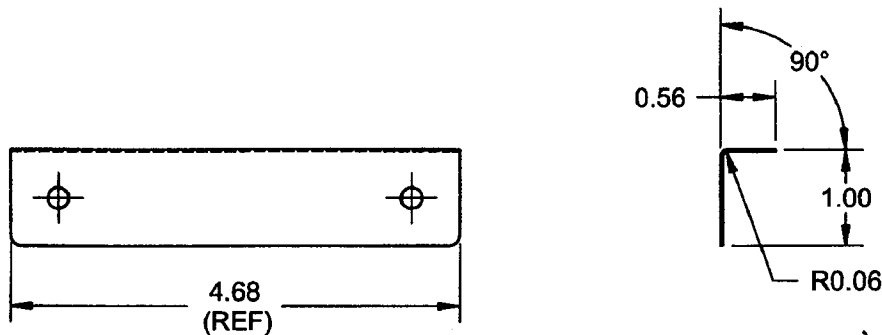


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DATE <b>06.01.23</b>	TITLE <b>SHUT-OFF VALVE BRACKET</b>	REV. A SHEET 4 OF 4 SCALE 1:2

*[Signature]* 06.04.03



### D3481-3F FLAT PATTERN



### D3481-3 ANGLE BRACKET

#### NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH  
26 GAUGE SS (0.018 THICK)  
(REF. DART SPEC. M304S26GA)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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